

**Work Order ID 70937**

Monday, June 20, 2011 8:26:21 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-Dec-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, &amp; B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

3 OK 11/06/20

BE 11/06/20

BE 11/06/20

B 11/06/27

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Page 3

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Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



Sub 6/27

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



H/Ae 11.06.28.

HandFinish

Memo

0.00

Hand Finishing

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/06/28

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Page 4

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.

cure time before cutting

Start Date: 11/06/28 Time: 3:40

Finish Date: 11/06/28 Time: 7:30

A/R Sikaflex-291 17116943

Sikaflex expiry date: 12/01/15

*Dr. 11/06/28*

*B 11/06/28*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*1 B 11/06/28*

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Page 5

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.  
A/R ☐ Aluminum Rod ☒ *M112860* *BE 11/04/29*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube *BB 11/07/04*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur *BE 11/07/04*

4- Install nut plate as per dwg *BB 11/07/04*

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control *8 11/07/04*

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Page 6

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Suloz/04

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

IX Ø M. 11/07/06

205



SprayPaint

Spray Painting

Memo

0.00

0.00

PRIME B 117319  
DELFLEET BLUE B 115985  
DELFLEET CLEAR B 117113 □

A 11 85 11-07-12

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Page 7

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

11 07 13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 8

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing					1	0	2	11/07/13
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. ✓ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 11/11/6040 Sikaflex expiry date: <input type="checkbox"/> 11/08								
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive								
	3-Install MS27039-4-06 Screw as per DEO 9153								
	4-Inspect for foreign object per QSI 024								
	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive ✓ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 11/11/6040 Sikaflex expiry date: <input type="checkbox"/> 11/08								
	6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: 11/117843								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 9

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

PPP 69960

W/O:		WORK ORDER CHANGES					
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Page 10

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14  
MF  
11-07-14

W/O:		WORK ORDER CHANGES					
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Monday, June 20, 2011 8:26:29 AM

Page 1

Work Order ID: 70937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD416 NAS1149D0463J Purchased

No

Each 0.0000

1



Washer

18117591



(21) 11/07/13

CCR264SS3-3 Purchased

No

Each 569.0000

2



(2)

11/04/07

Cherry Rivet

## Location

## Loc Qty

## Loc Code

FP-B

2

113973

2

ST311

567

117086

71

117849

496

CR3212-4-03 Purchased

No

Each 1,216.000

2



(2)

11/04/07

Cherry Rivet

## Location

## Loc Qty

## Loc Code

FP-B

2

110139

2

ST311

1214

114859

1214

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Page 2

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Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

12.0000

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

12

62684

1

68135

1

68136

10

D2647

Manufactured No

Each

25.0000

1



Cap

Location

Loc Qty

Loc Code

LG002

25

55352

25

D2649

Manufactured No

Each

111.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

99

68224

2

70394

97

LG001

12

65317

1

68507

11

D2654-5

Manufactured No

Each

3.0000

1



Web

Location

Loc Qty

Loc Code

LG

3

70229

3

Monday, June 20, 2011 8:26:29 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Monday, June 20, 2011 8:26:29 AM

Page 3

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Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

Each 30.0000



Nut Plate



1  
①

B 11/07/04

Location

Loc Qty

Loc Code

ST020

30

55366

17

70088

13

MS27039C1-08 Purchased No

Each 804.0000



SCREW



56

M 11/07/13

Location

Loc Qty

Loc Code

FP-A

1

116022

1

ST293

803

116373

3

117291

800

ALS4-1032-130 Purchased No

220 Each 1,498.000



Insert



54

54

M 11/07/13

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

1490

117717

1490

AN960C10L NAS1149C0332 Purchased No

220 Each 0.0000



washer

11118306



54

54

(x54) M 11/07/13

AN960JD10L NAS1149D0332J Purchased No

220 Each 0.0000



Washer

11117291



2

2

(x2) M 11/07/13

Monday, June 20, 2011 8:26:29 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:26:29 AM

Work Order ID: 70937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220 Each

82.0000 1 1



Aft Cap



ML 11/07/13

Location

Loc Qty

Loc Code

FP004

62

1374038

68280

62

ML

FP006

20

62678

20

ML

D2651-1

Manufactured No

220 Each

251.0000 14 14



Plug



ML 11/07/13

Location

Loc Qty

Loc Code

fpa

109

69018

109

870942

FP-A

142

X14

57869

1

66445

10

67760

97

70827

30

70839

4

D2651-3

Manufactured No

220 Each

536.0000 14 14



O-Ring



ML 11/07/13

Location

Loc Qty

Loc Code

FP-A

536

61962

104

66956

432

X3

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:26:30 AM

Page 5

Work Order ID: 70937

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011



Start Qty: 1.00

Required Qty: 1.00

D3535-11	Manufactured	No	220	Each	8.0000	1	1
							<u>22 110713</u>
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP019	8	
68362	8	<u>X1</u>

D3535-23	Manufactured	No	220	Each	20.0000	1	1
							<u>22 110713</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	20	
66236	-1	
67594	8	
68342	13	<u>X1</u>

D3535-35	Manufactured	No	220	Each	30.0000	1	1
							<u>22 110713</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP018	10	
65926	1	
67598	1	
68348	8	
ST	20	
69756	20	<u>X1</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:26:30 AM

Page 6

Work Order ID: 70937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-11      Manufactured      No      220      Each      13.0000      1      1  
Gasket  
JH 6/20/11

Location	Loc Qty	Loc Code
FP011	13	
46649	1	
46715	4	
65574	8	

D3536-23      Manufactured      No      220      Each      39.0000      1      1  
Gasket  
JH 6/20/11

Location	Loc Qty	Loc Code
FP011	39	
43406	1	
66560	12	
69902	26	

D3536-35      Manufactured      No      220      Each      27.0000      1      1  
Gasket  
JH 6/20/11

Location	Loc Qty	Loc Code
FP012	27	
67599	1	
69755	26	

D3537-1      Manufactured      No      220      Each      10.0000      6      6  
Wearpad  
JH 6/20/11

Location	Loc Qty	Loc Code
FP017	10	
69817	10	B 70686

Monday, June 20, 2011 8:26:30 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 20, 2011 8:26:30 AM

Page 7

Work Order ID: 70937



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

220 Each

9.0000

1

1



Wearpad



110713

Location

Loc Qty

Loc Code

FP017

1

1370817

xl

35697

1

FP19

8

69292

8

MS27039-4-06

Purchased

No

220 Each

57.0000

1

1



Screw



110713

Location

Loc Qty

Loc Code

FP-A

23

115460

23

ST292

34

115460

34

xl

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70937  
R11-06-20

RELEASED  
02-27-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		208/407 SKIDTUBE ASSEMBLIES	NTS
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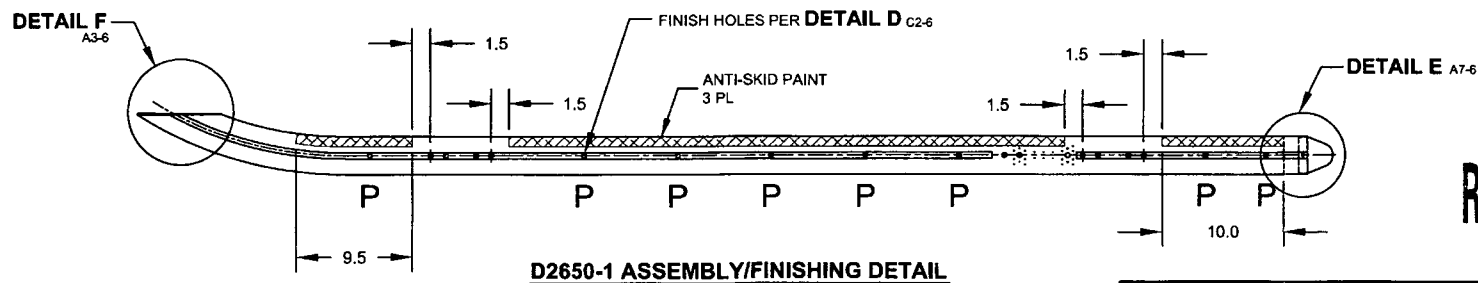
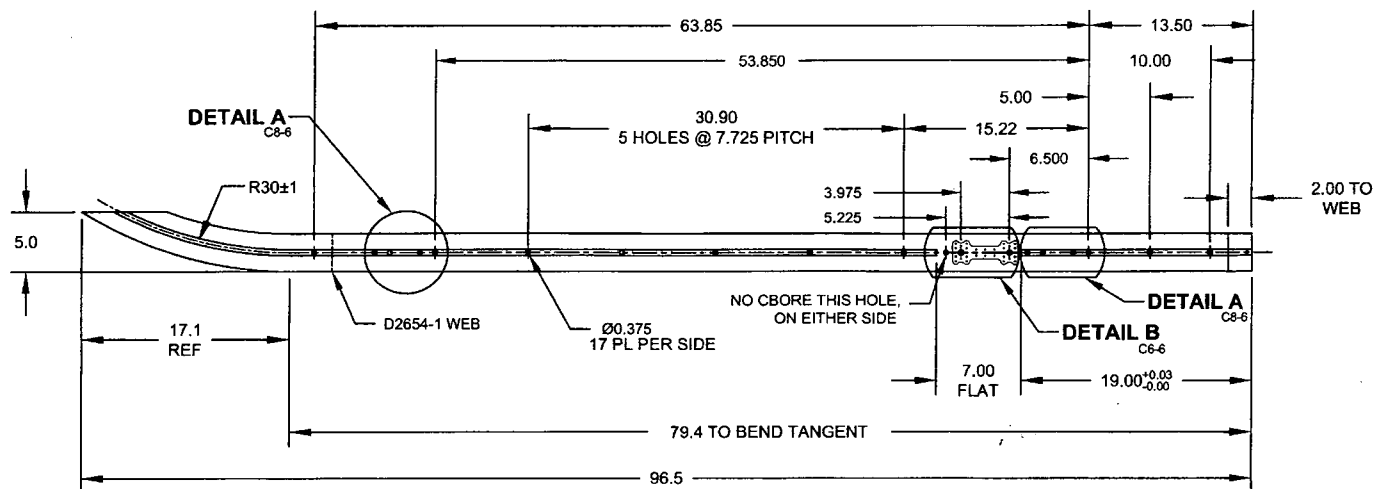
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



wb70937

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680922/107

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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**Dart Aerospace Ltd**

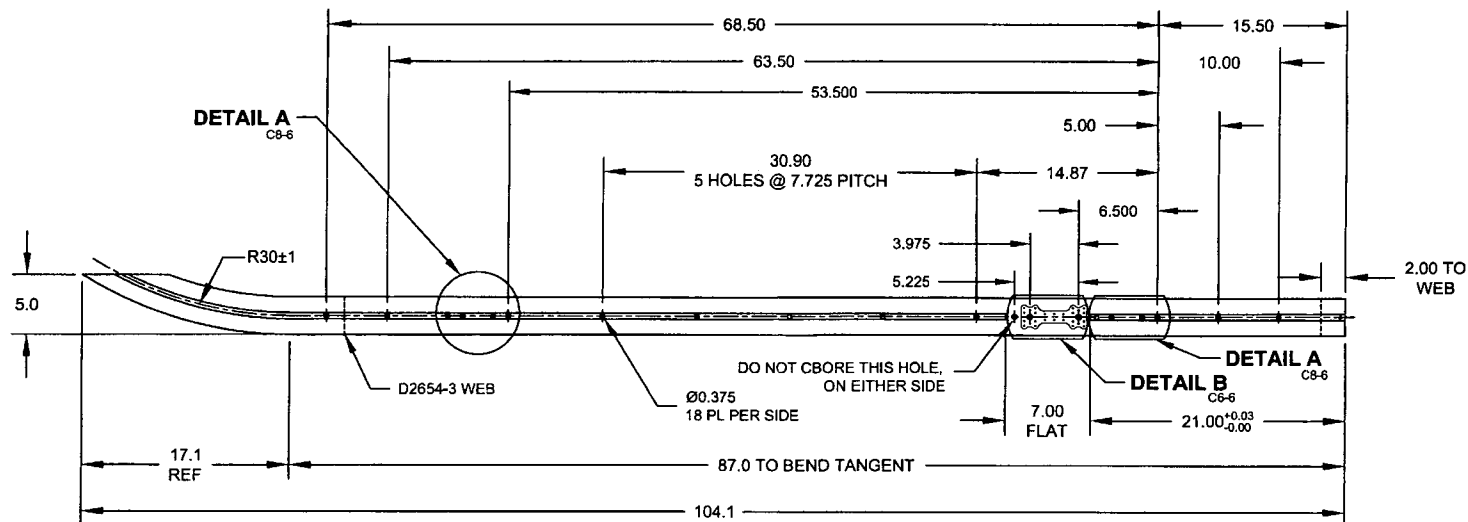
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

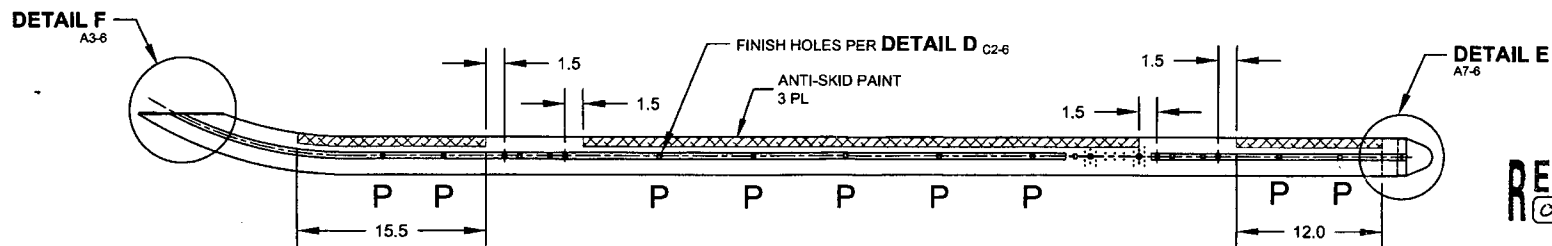
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-3 BENDING/DRILLING DETAIL**



**D2650-3 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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**RELEASED**  
08 07 22 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

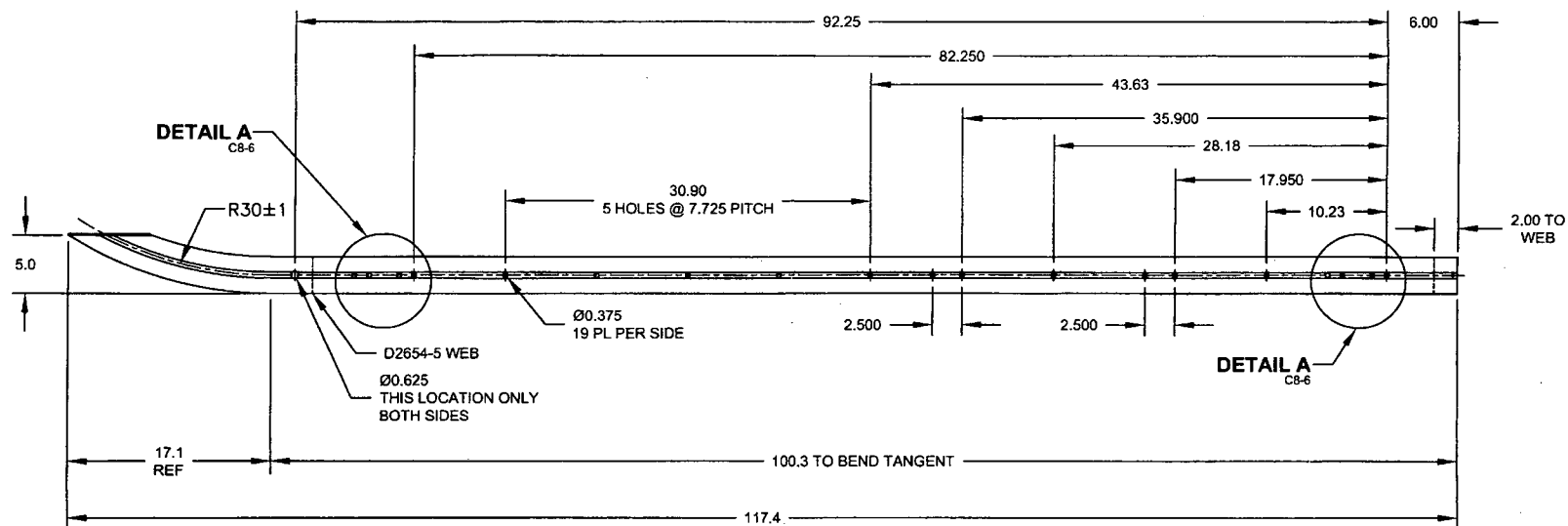
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

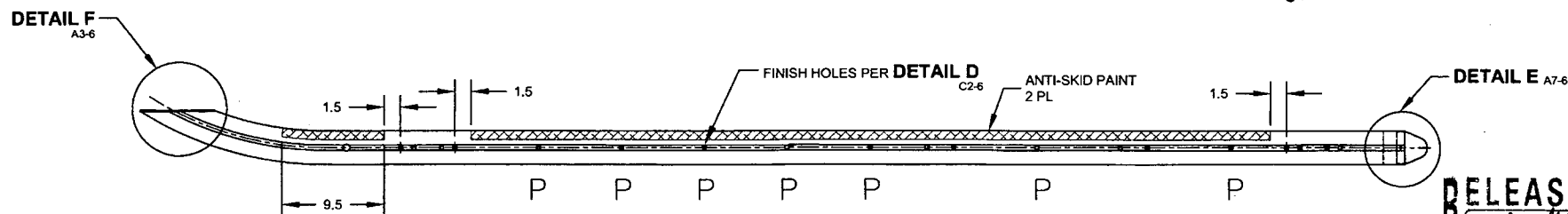
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2650-5 BENDING/DRILLING DETAIL**



**D2650-5 ASSEMBLY/FINISHING DETAIL**

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7								

**NOTE:** Date & initial all entries



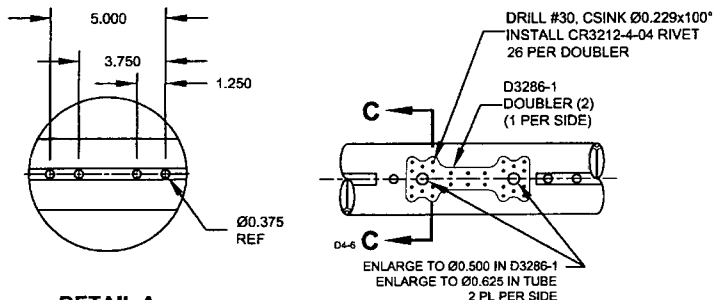
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

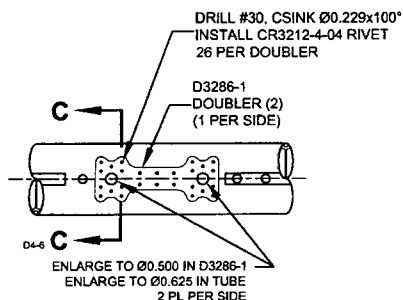
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

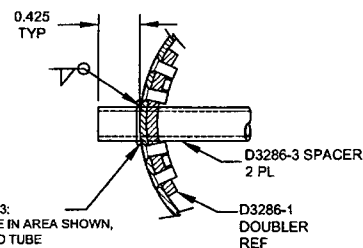


**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

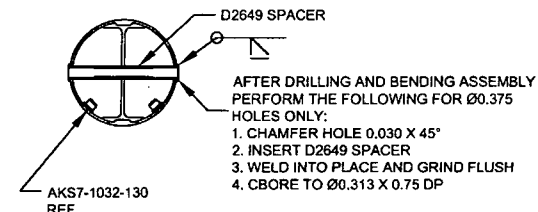


**DETAIL B**  
SCALE 2X  
C3-2  
C3-3

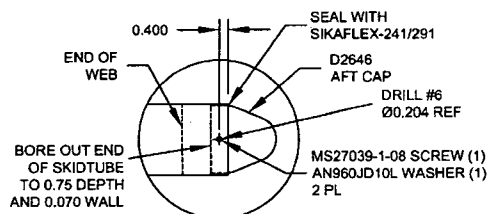
**SECTION C-C** C7-6  
SCALE NONE



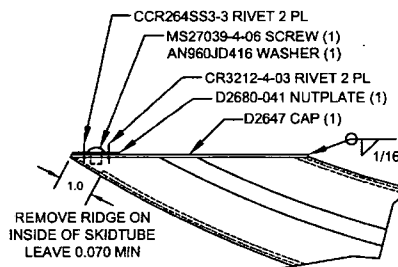
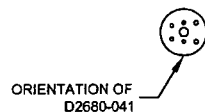
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
08-09-22-19

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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*w/b 70937*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 255  
~~255~~

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 69953  
Part number: 206 - 642 - 341  
Description: 206  
Welding Process: Tig ☒ Mig ☐  
Base material: \_\_\_\_\_  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Dunn Date of Test Coupon 11.06.14  
Welder Barclay Elliot Date of Test Coupon 11/06/14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld